

Work Order ID 86503

Tuesday, July 03, 2012 10:35:55 AM

86503

UNALIK

Page 1

Item ID: D3371-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pedal Lock Assembly

Start Date: 7/3/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/4/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *7-03-03* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3371

Rev B

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<i>M120369</i>

①

SB 12/07/04

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

ix

SB 12/07/04

C/638

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 3

Item ID: D3371-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Pedal Lock Assembly

Stop ***NS2***Start Date: 7/3/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/4/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/7/49
ME
12-07-04

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Picklist Print

Tuesday, July 03, 2012 10:35:54 AM

Page 1

Work Order ID: 86503

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 7/3/2012

Required Date: 7/4/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 3/16" Dowel Pin .5" long		Purchased	No			120	Each	186.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		186							
				106673		98							
				108114		61			2				
				17848		27							
AN526C832R6 Screw		Purchased	No			120	Each	282.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		282							
				16612		282			4				
AN960-416 Washer	NAS1149F0463P	Purchased	No			140	Each	0.0000	2	2			
CBL-1240 Cable		Purchased	No			130	f	807.1985	1.6666	1.7543158			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		807.198501							
				113565		3.911789			1.7543158				
				119021		290.253312							
				119690		13.0334							
				122190		500							
CBL-460 Loop Sleeve		Purchased	No			130	Each	632.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		632							
				121574		632			2				
D2728-7 Dart Logo label		Manufactured	No			120	Each	0.0000	0	0			

SB 12/07/04

SB 12/07/04

SB 12/07/04

SB 12/07/04

SB 12/07/04

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Page 2

Work Order ID: 86503

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 7/3/2012

Required Date: 7/4/2012

Start Qty: 1.00

Required Qty: 1.00

D3371-1
Pedal Lock Base

Manufactured No

120 Each 1.0000

1 1

SB 12/6/104

Location

Loc Qty

Loc Code

ST -8
ST485 1
70040 1
ST490 8

B83515

1

D3371-3
Pedal Lock Cover

Manufactured No

120 Each 0.0000

1 1

SB 12/6/104

D3373-7
Cam Lock

Manufactured No

120 Each 20.0000

1 1

SB 12/6/104

Location

Loc Qty

Loc Code

ST039 20
80276 20

B22292

D3384-1
Cyclic Sock

Manufactured No

130 Each 2.0000

1 1

SB 12/6/104

Location

Loc Qty

Loc Code

ST486 2
77011 2

1

D3385-3
Hinge

Manufactured No

120 Each 68.0000

1 1

SB 12/6/104

Location

Loc Qty

Loc Code

ST041 68
22387 68

1

HX-81
1/4"-20 SHCS 3/8" long

Purchased No

140 Each 82.0000

1 1

SB 12/6/104

Location

Loc Qty

Loc Code

ST 50
120357 50
ST390 32
114383 1
120773 31

1

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Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

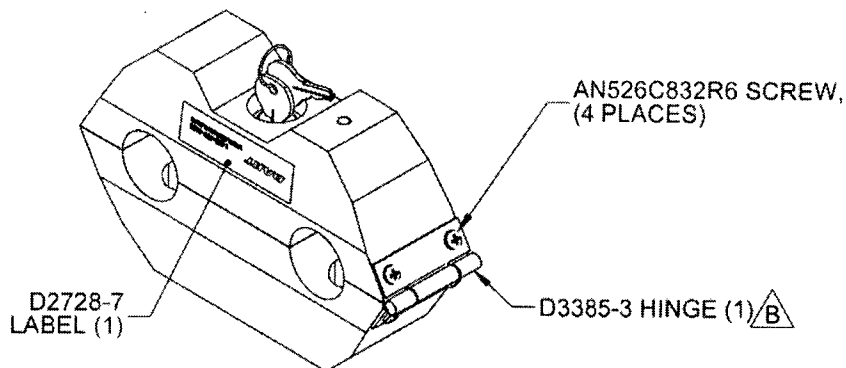
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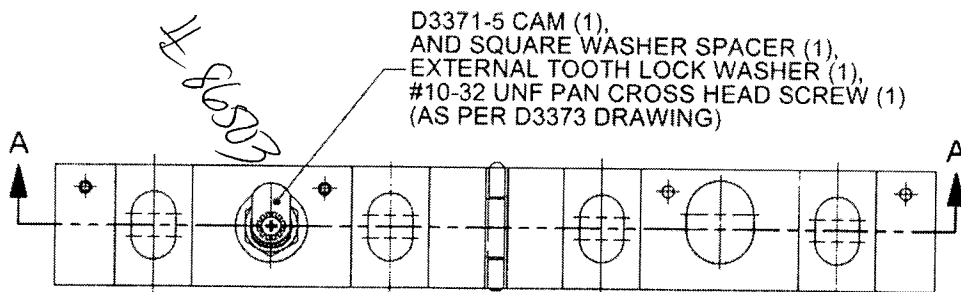
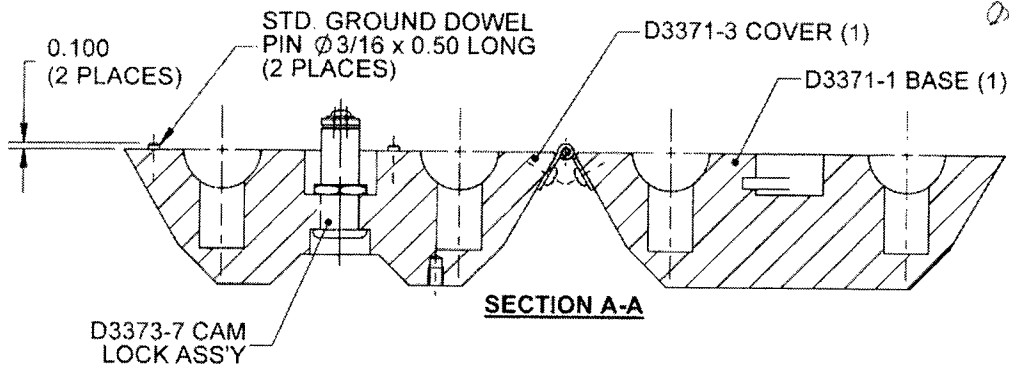


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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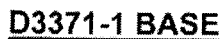
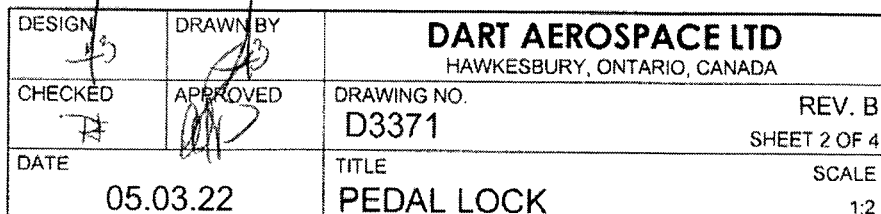
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NOTE: Date & initial all entries



- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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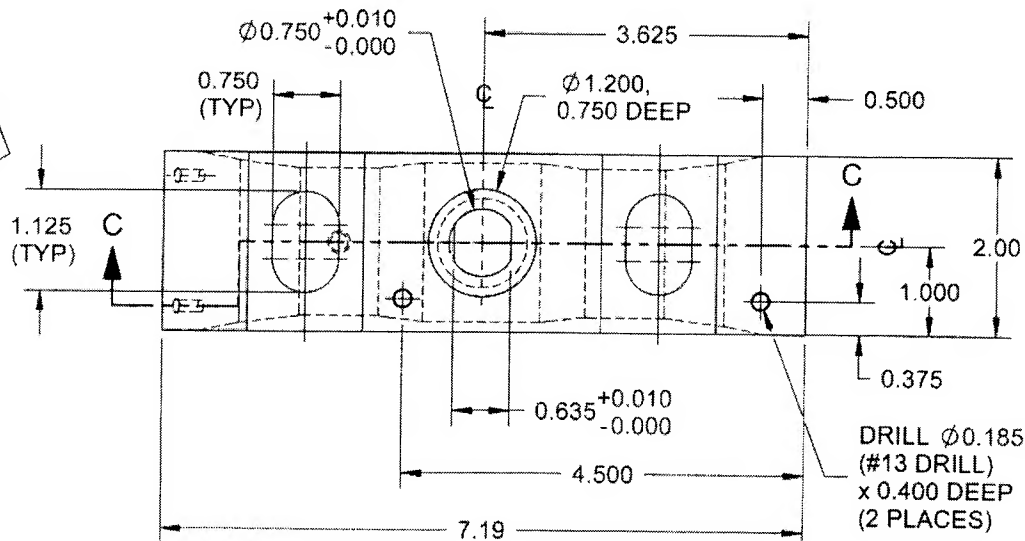
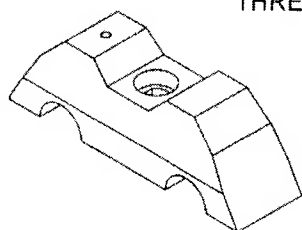
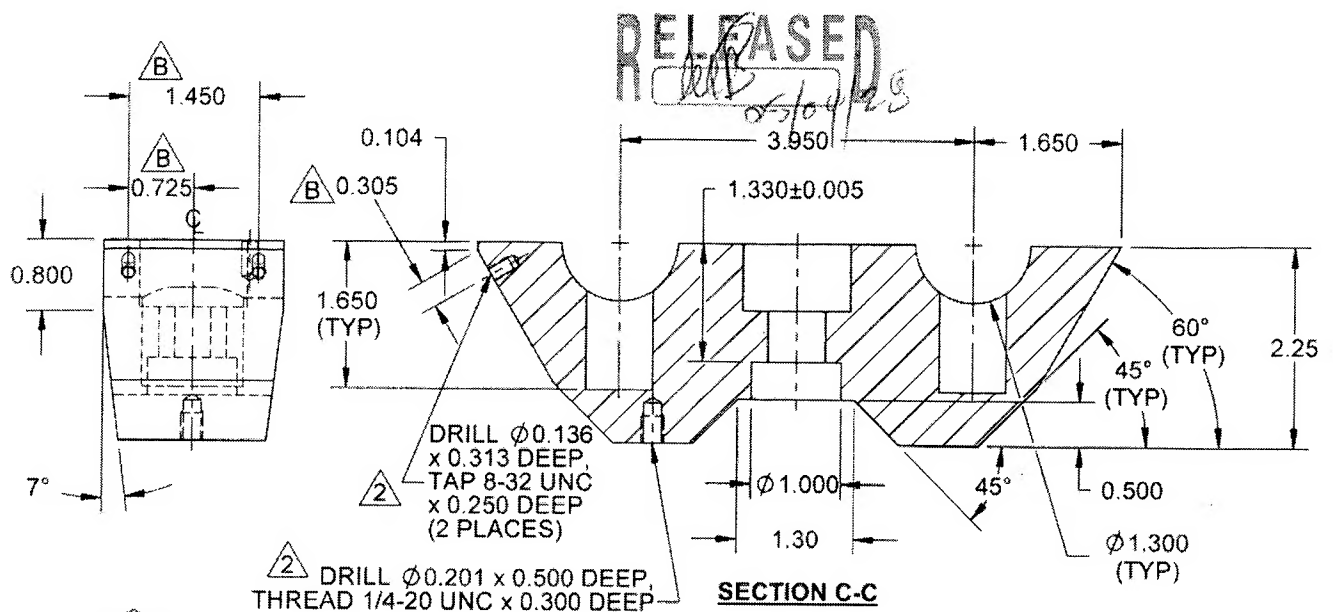
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
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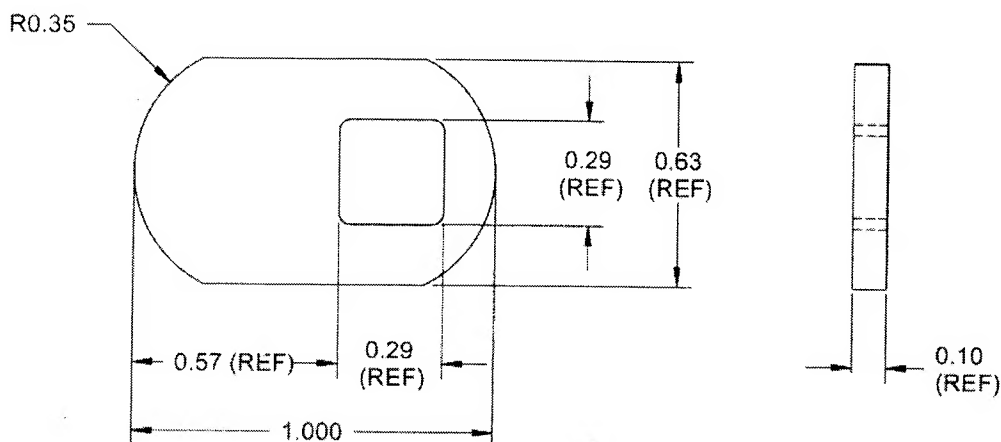
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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